

Date: Tuesday, 11/21/2006 11:34:28 AM  
 User: Kim Johnston

## Process Sheet

CLENIS

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET  
 Job Number : 29572  
 Estimate Number : 12450  
 P.O. Number : N/A  
 This Issue : 11/21/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : SMALL / MED FAB  
 Previous Run : 29539  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 06-06-09 JLM

Part Number : D351611  
 Drawing Number : D3516 REV. B Prelim Log. 11-21  
 Project Number : N/A  
 Drawing Revision : B  
 Material : N/A  
 Due Date : 11/28/2006 Qty: 20 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 .125 Sheet



Comment: Qty.: 0.0218 sf(s)/Unit Total: 0.4368 sf(s)  
 304/316 .125 Sheet 11GA  
 (M304S11GA)  
 Batch: M101463

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3516  
 Dwg Rev: B  
 Prog Rev: B

M 06 11 22

(20)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 11 22

(20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/11/22

(20)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Form as per Dwg D3516

SA 06/11/22

(20)





PTO

20

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/11/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/11/28	5	1 part was out of tolerance	 BGRN	Scrap & destroy	ES 06/11/29	 06-11-29	 BGRN	 06-11-29

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:34:28 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29572

Part Number: D351611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MOG/11/29 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

PD 06-11-29 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

04/11/29

Job Completion



U 06/11.29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**PRELIMINARY ISSUE**

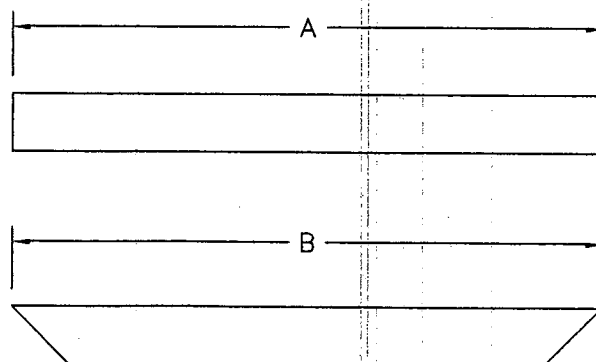
06.11.06

DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

**PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

△ B



**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
(REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS  
(REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

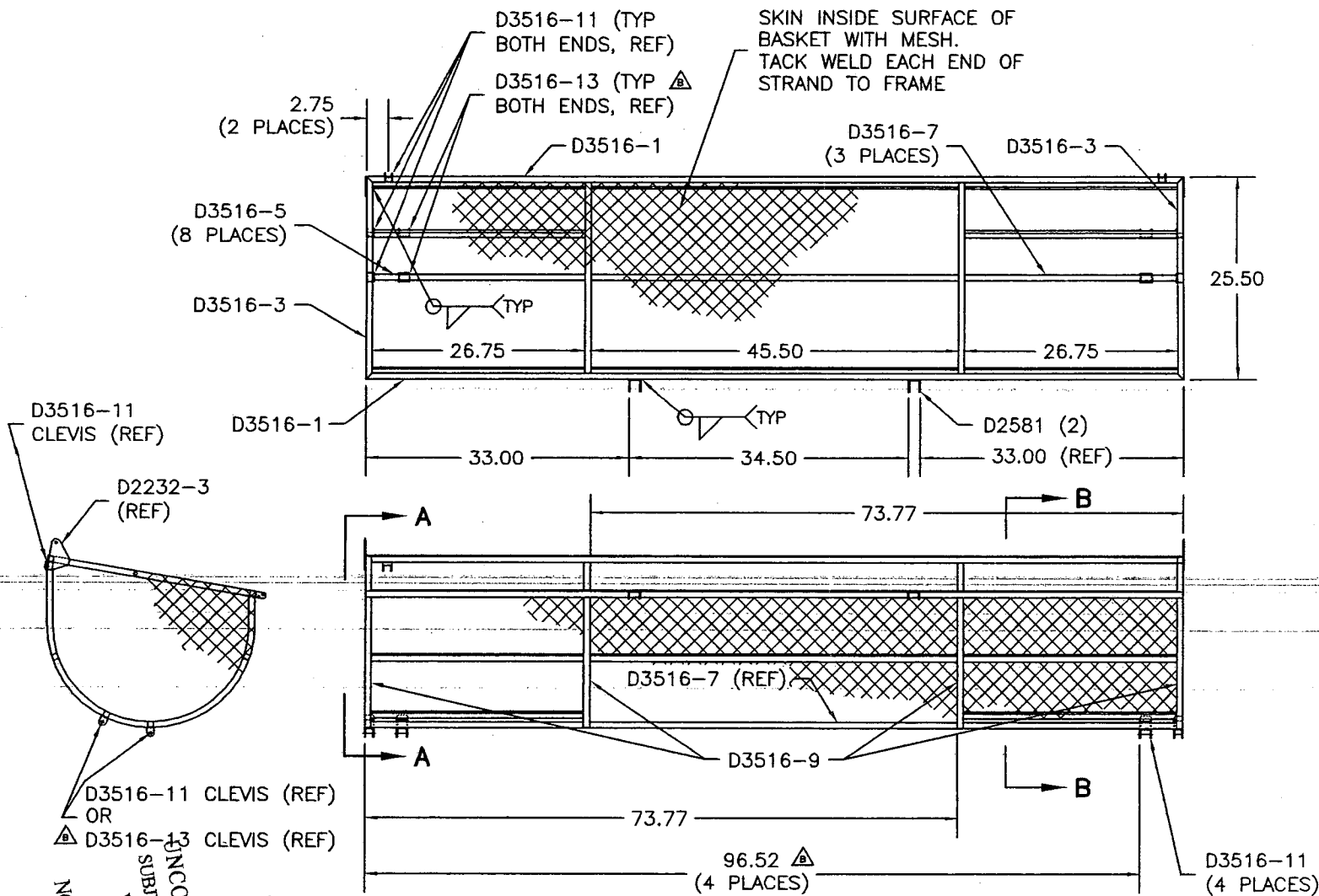
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06.11.06

DESIGN BY	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	APPROVED	DRAWING NO. D3516	SHEET 2 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:20



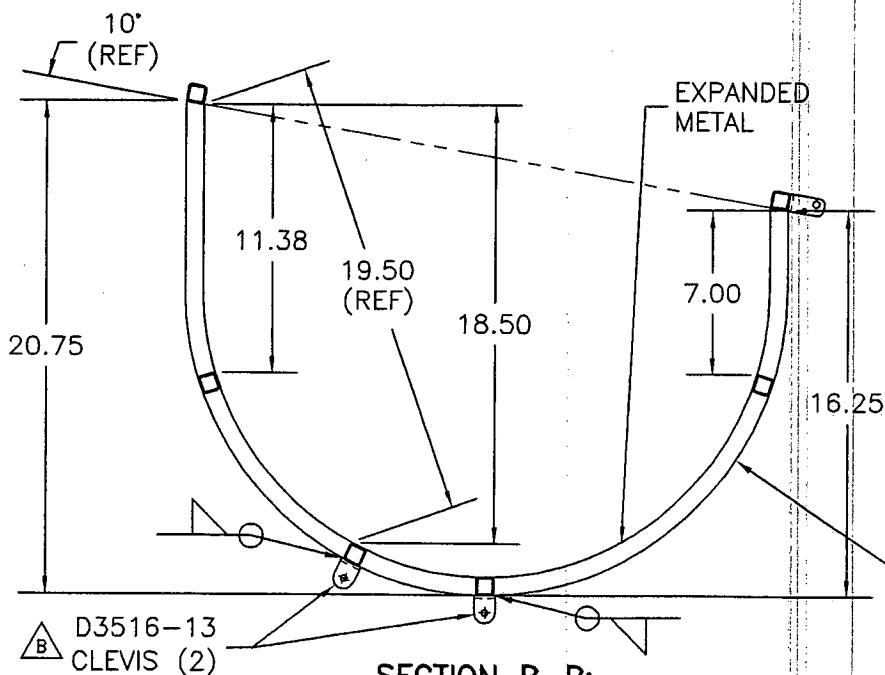
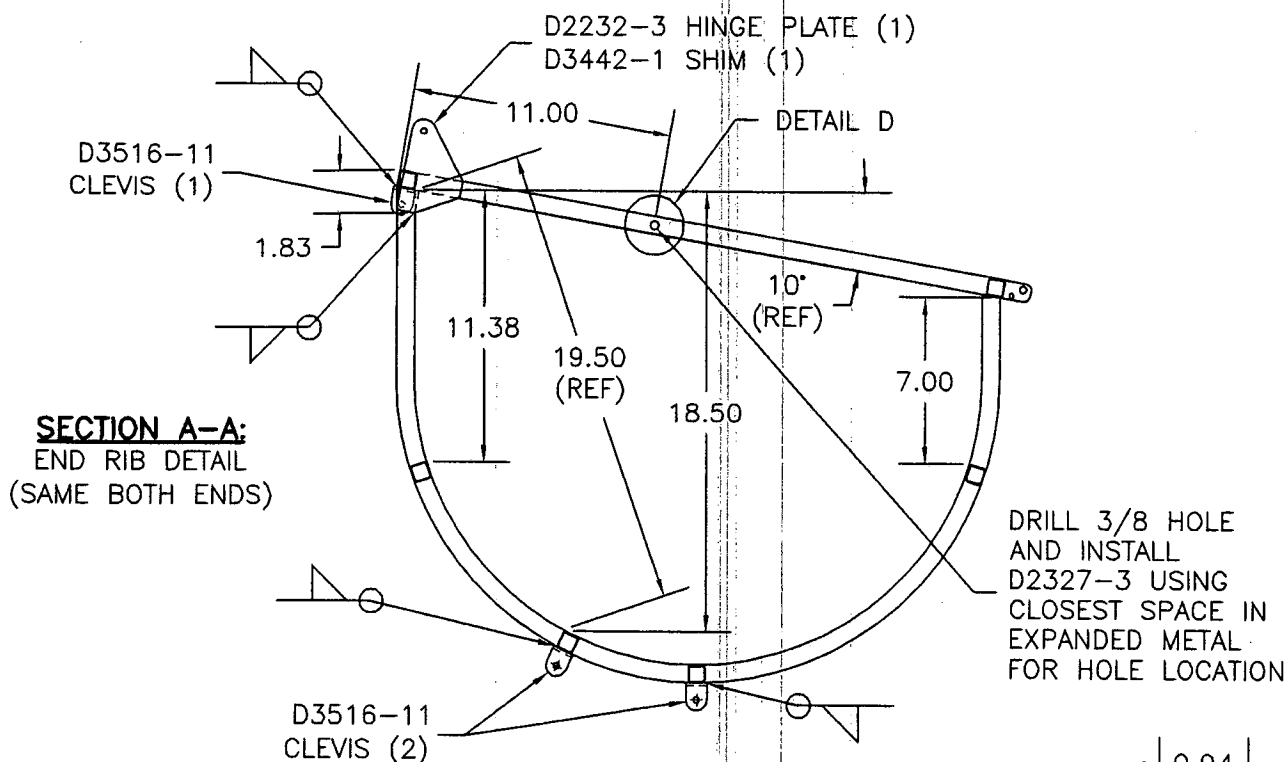
D3516-041 BASKET BASE ASSEMBLY

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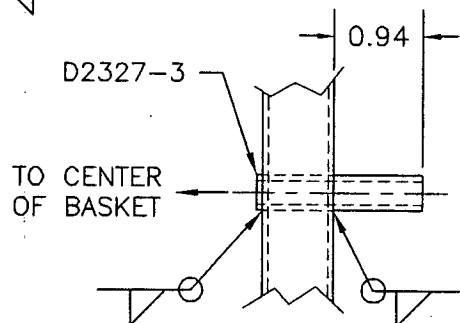
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DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:8



**SECTION B-B:**  
CENTER RIB DETAIL  
(2 PLACES)



**DETAIL D**

SHOP COPY  
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D3516-9 RIB  
(MAKE FROM D2232-3)  
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NO. 29572

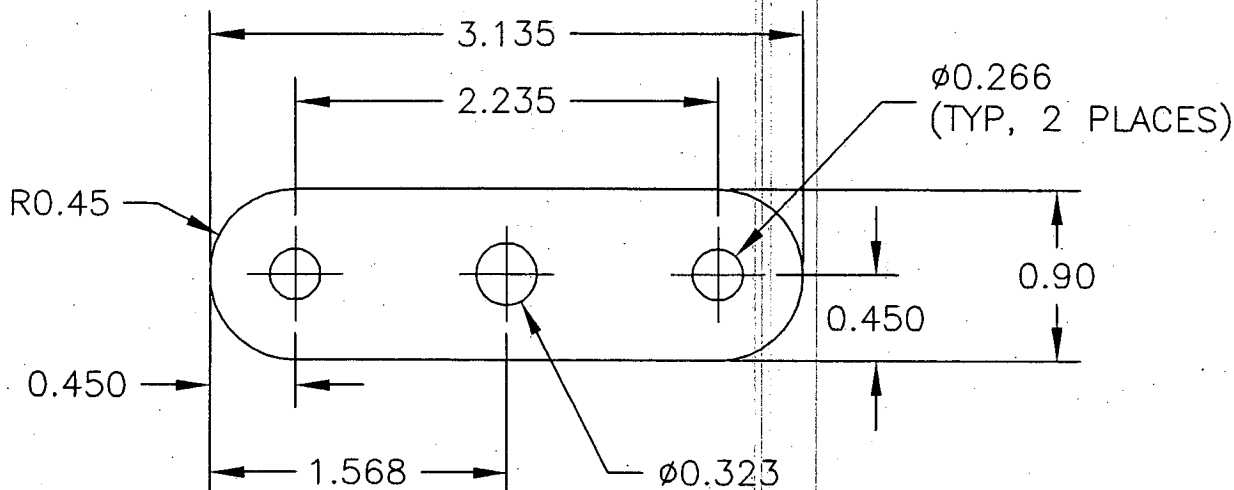
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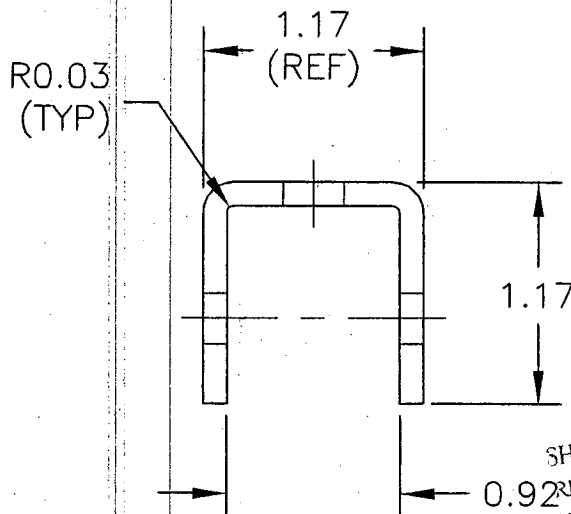
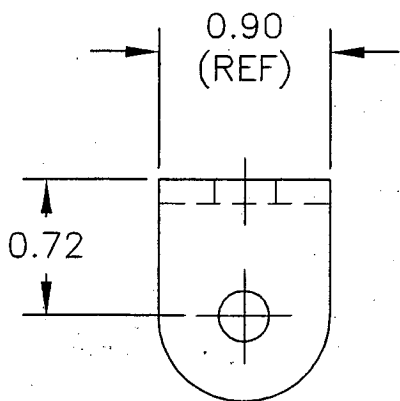
OC.V.09

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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



#### D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)



#### D3516-11 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-11F
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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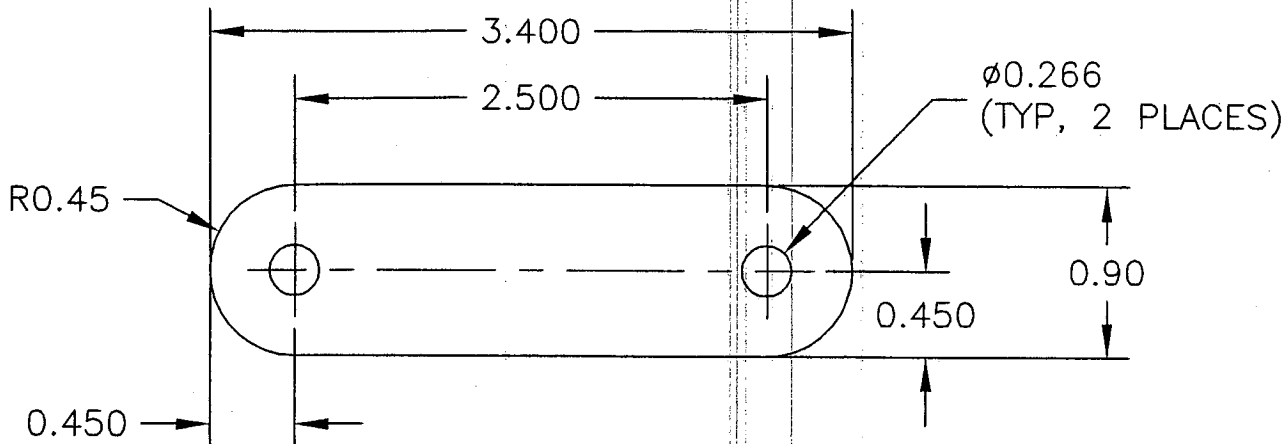
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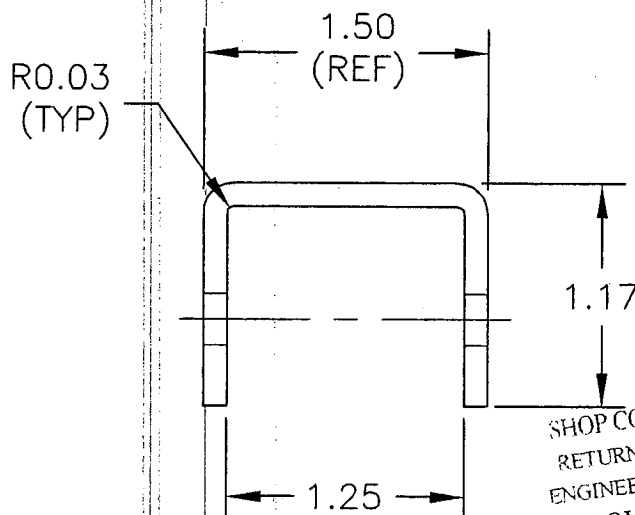
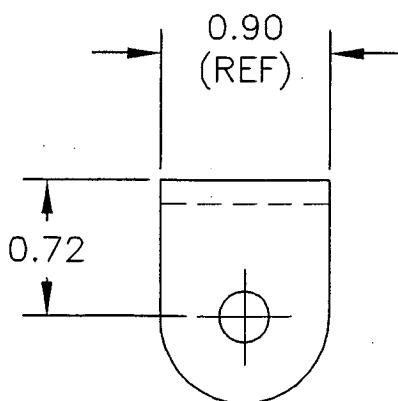
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CHECKED	APPROVED	DRAWING NO. D3516	REV. B SHEET 5 OF 5
DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:1



**D3516-13F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)



**D3516-13 CLEVIS BENDING DETAIL**

- 1) MATERIAL: MAKE FROM D3516-13F
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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